

Work Order ID 128428-2 **SPUT*****128428***

Page 1

Item ID: D3179-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Litter Tie Down (Non-Locking)

Stop ***NS2***

Start Date: 1/16/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/16/15 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-01-19 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3179	Rev D								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.130" long

6

Ø

DAS
44
9-89

15/01/23

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: D 2-
Deburr per dwg D3179-1

6

Ø

DAS
20
9-89

15-01-25

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6

Ø

DAS
20
9-89

15-01-25

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Page 2

Item ID: D3179-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Litter Tie Down (Non-Locking)
 Start Date: 1/16/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									DAS
QC	Memo	0.00				6	0		08
Quality Control									9-89

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	QC7-Inspect Chemical Conversion Coat	0.00							
150									DAS
QC	Memo	0.00				6	0		34
Quality Control									9-89

Handwritten: 15/01/29

Handwritten: 6 x 0 15/01/29

Handwritten: 6 0 15-1-30

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Item ID: D3179-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Litter Tie Down (Non-Locking)
 Start Date: 1/16/15 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 129808</i> Memo START TIME: <i>10:20</i> FINISH TIME: <i>10:50</i> OVEN TEMPERATURE: <i>370°</i>	0.00 0.00				<i>6</i>	<i>0</i>	<i>15-1-30</i>	<i>DAS 34 9-89</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(2)</i>			<i>DAS 38 9-89</i> <i>FEB 02 2015</i>
180 *180* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3179 <i>Drill Holes #D 246</i>	0.00 0.00				<i>2x</i>		<i>15/02/02</i>	<i>DAS 36 9-89</i> <i>15-02-02</i>

0-80
SS
DAG

DQA:

Date: 15/03/25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~R211~~

Date: 15/03/23

Work Order update only ☐

Work Order: 128428	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. D3179-041	Rework ☒	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. 15-4690	Scrap ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-01-30	100	2	Find scratch after paint		Grind scratch strip and re powder coat	PD 15-01-30	38 9-89	DAS 9 9-89
Doc/Data							CL 15-02-01	JAN 30 2015	
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☒ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

1000 1000

1000 1000

1000 1000

1000 1000

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Item ID: D3179-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Litter Tie Down (Non-Locking) Stop *NS2*

Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/16/15 Start Qty: 6.00 *6*

Required Date: 1/16/15 Req'd Qty: 6.00 *6*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190						(2)			DAS 38 9-89
QC	Memo	0.00							
Quality Control									

FEB 02 2015

200	Identify as per dwg & Stock Location: <u>St 225</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

DAS
86
9-89

FEB 05 2015

210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

15/2/6 *[Signature]*

[Signature] 15-2-6

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Parent Item: D3179-041

D3179-041

Parent Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
AS PER REV D JLM 13-05-24 VERIFIED BY:DD
IPP Rev:C 08-12-10 add part list DD verified by:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2372		Manufactured	No			180	Each	5.0000	2	12			
D2372													
Quick Release													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
					124469			5					
D2444		Manufactured	No			180	Each	6.0000	1	6			
D2444													
Pip Pin Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				6					
					123487			4					
					124412			2					
D6201		Manufactured	No			180	f	27.4990	1.0125	6.394737			
D6201													
"T" Extrusion													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT028				27.499					
				* 113608				6.166					
				* 117448				1.333					
				124165				20					

Picklist Print

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Work Order ID: 128428

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Parent Item: D3179-041

D3179-041

Parent Item Name: Litter Tie Down (Non-Locking)

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

180

Each

2,045.000

1

6

MS21042L3

Nut

15/02/02
DAS
36
9-89

Location

Loc Qty

Loc Code

FP001

447

M130922

447

ST305

1595

M130799

31

M131264

1564

ST307

3

123900

3

MS27039-1-13

Purchased

No

180

Each

773.0000

1

6

MS27039-1-13

Screw

15/02/02
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

133

124326

133

ST273A

300

124326

300

ST285

340

125654

340

NAS1149D0332J

Purchased

No

100

Each

1,886.000

3

18

NAS1149D0332J

Washer

15/02/02
DAS
36
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

37

m130325

37

ST269

1835

m130325

1835

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Shop Packet Print

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8

7

6

5

4

3

2

1

ITEM	QTY	P/N	DESCRIPTION
	X	D3179-041	LITTER TIE DOWN BRACKET
1	2	D2372	QUICK RELEASE
2	1	D2444	PIP PIN
3	1	D3179-1	LITTER TIE DOWN BRACKET
4	1	MS21042L3	NUT
5	1	MS27039-1-13	SCREW
6	3	NAS1149D0332J	WASHER (AN960JD10L)

D2444 PIP PIN

MS27039-1-13 SCREW
NAS1149D0332J WASHER 3PL
MS21042L3 NUTFWD BRACKET
OUTBDD2372 QUICK
RELEASE
2 PL

D3179-1 LITTER TIE DOWN BRACKET

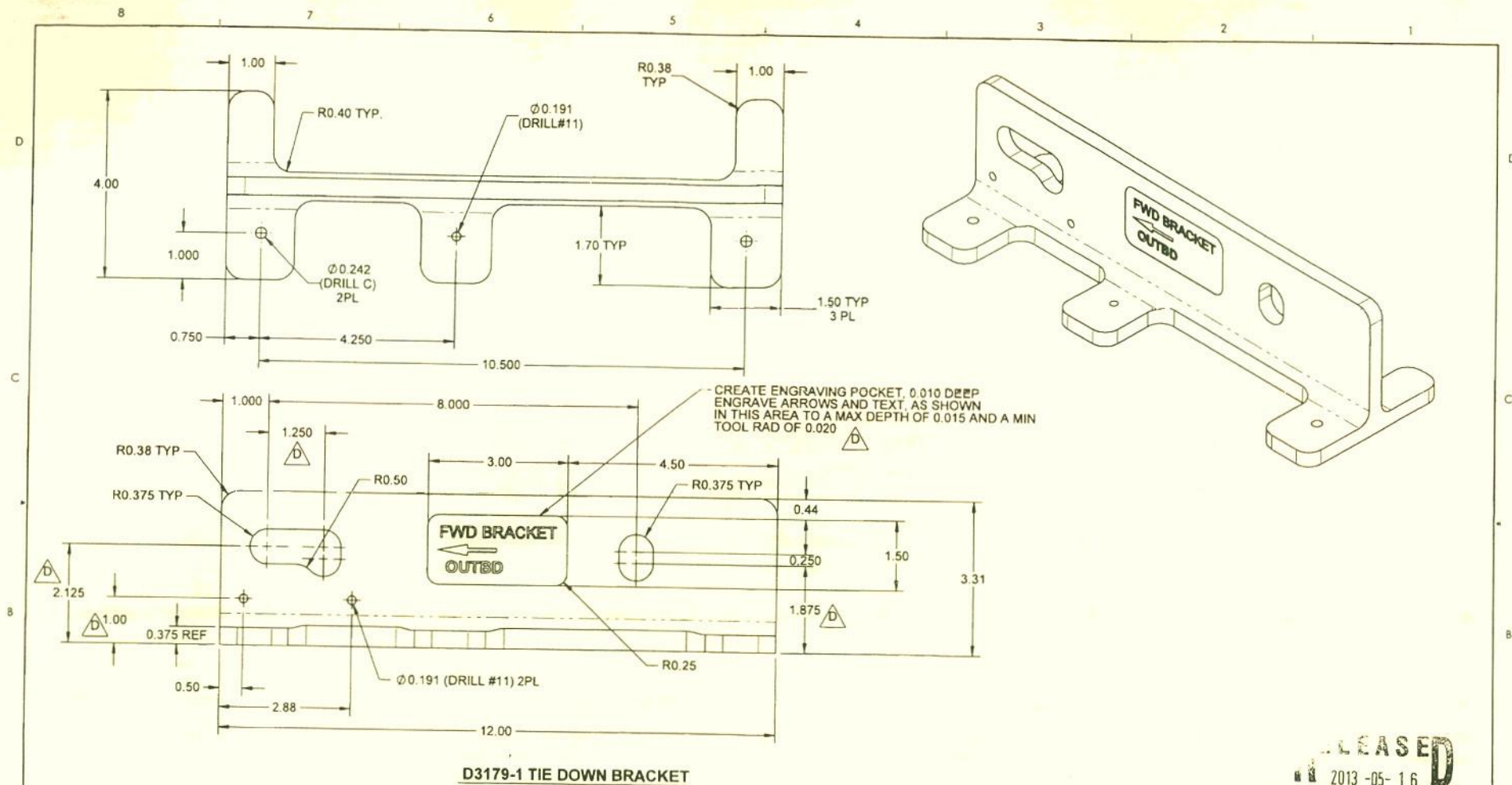
D3179-041 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3179-041" ON BOTTOM FACE USING FINE POINT PERMANENT INK MARKER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.79 lbs

128428 MJS
15-01-19RELEASED
2013-05-16

D	POSITION AND SHAPE OF LITTER CAPTURE SLOTS CHANGED (ZN B4-2, B8-2, C7-2); ADD ENGRAVING NOTE (ZN C4-2); REF CIR13-15	DB	13.03.22
C	ADD D3179-041 & PARTS LIST (ZN B8-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING, FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3179 TITLE LITTER TIE DOWN BRACKET COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL; AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	2/1		
APPROVED	1/2		
DE APPR.	1/2	REV. D	
DATE	13.03.22	SHEET 1 OF 2	
		SCALE NTS	



NOTES

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.90 lbs

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	al	D3179	SHEET 2 OF 2
APPROVED	143	TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
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